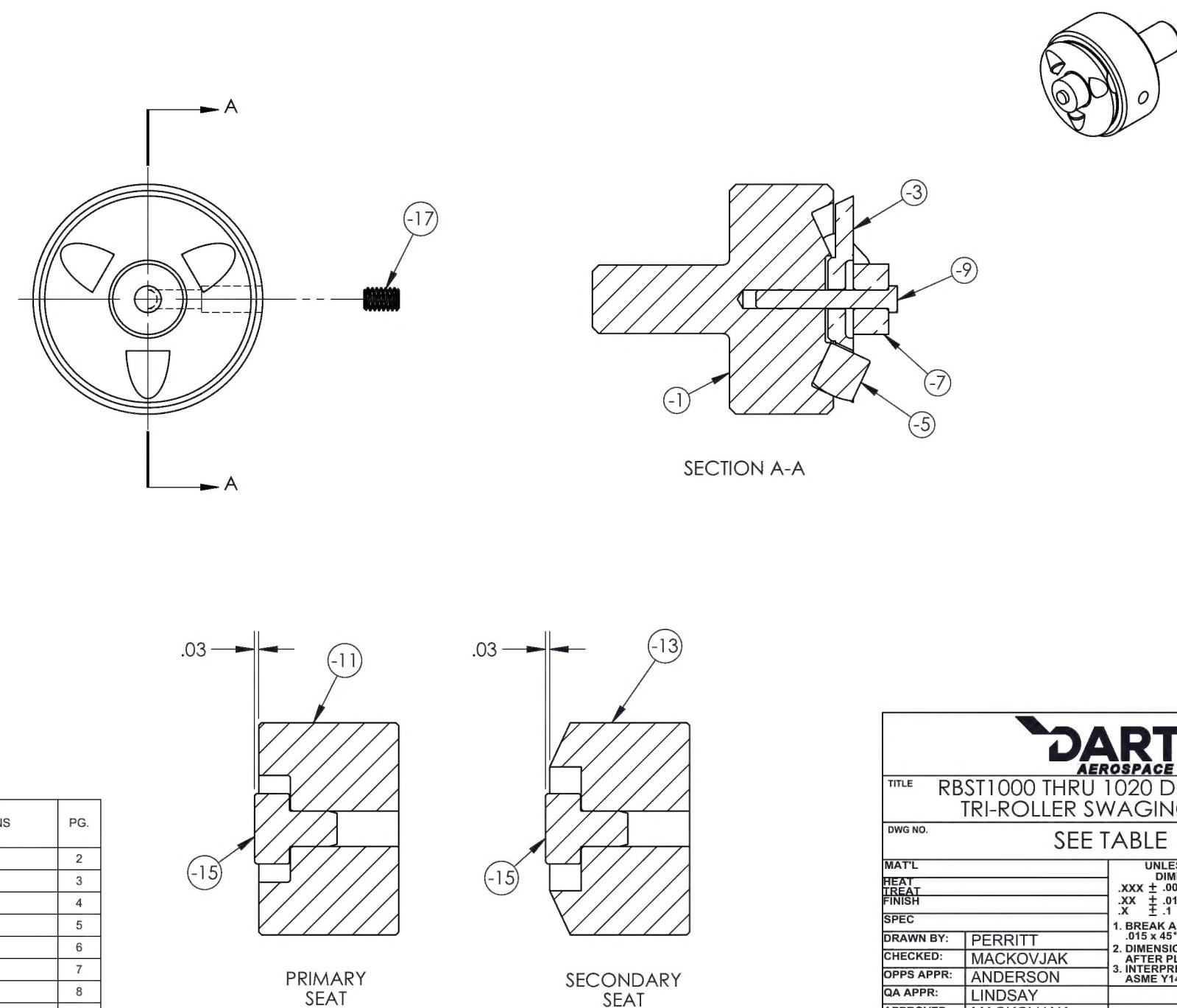


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BEARINGS & TOOLS COVERED		
BEARING NUMBER	BEARING NUMBER	TOOL NUMBER
MS14101-3		RBST1000
	MS14103-3	RBST1001
	MS14103-4	RBST1002
MS14101-4		RBST1003
	MS14103-5	RBST1004
MS14101-5		RBST1005
MS14101-6	MS14103-6	RBST1006
MS14101-7	MS14103-7A	RBST1007
	MS14103-7	RBST1008
MS14101-8		RBST1009
	MS14103-8	RBST1010
MS14101-9		RBST1011
	MS14103-9	RBST1012
MS14101-10		RBST1013
	MS14103-10	RBST1014
	MS14103-12	RBST1015
MS14101-12		RBST1016
MS14101-14		RBST1017
	MS14103-14	RBST1018
MS14101-16		RBST1019
	MS14103-16	RBST1020

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	ROLLER FIXTURE	0-1 DRILL ROD	SEE TABLE	2	
		-3	1	RETAINER	BRONZE	SEE TABLE	3	
		-5	3	ROLLER	STEEL	GAUGE PIN MSC #89031009	4	
		-7	1	GUIDE	BRONZE	SEE TABLE	5	
		-9	1	PIN	STEEL	(MCMMASTER-CARR #98378A909)	6	
		-11	1	PRIMARY SEAT	4140/4142	SEE TABLE	7	
		-13	1	SECONDARY SEAT	4140/4142	SEE TABLE	8	
		-15	2	LOCATING PIN	1018/1020 CR	SEE TABLE	9	
B/O	-17	1	SOCKET HEAD SET SCREW	S.S.	#8-32 X 1/4 (MCMMASTER-CARR #97705A406)		1	

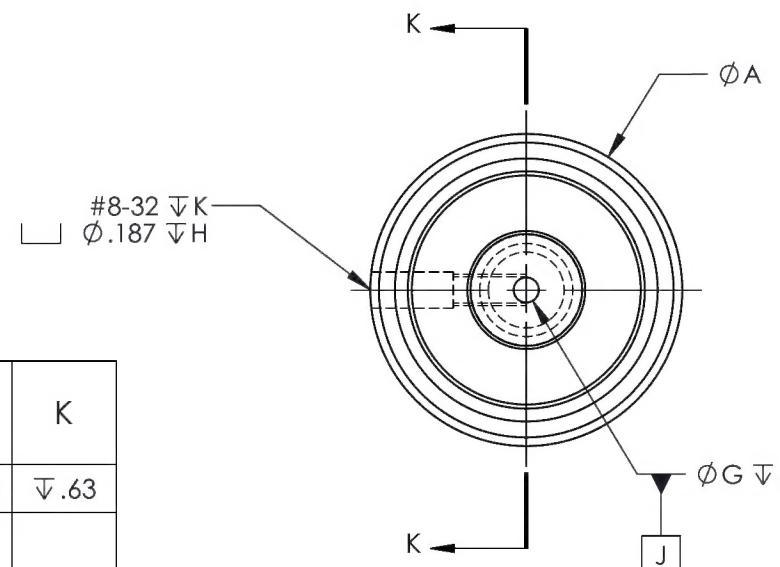
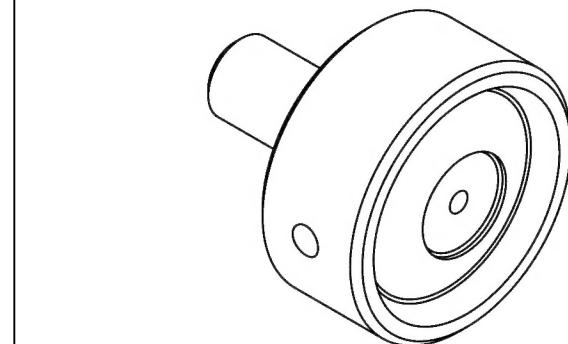
REV			ECR		DESCRIPTION		REVISIONS		
1					CHANGED TITLE, -1 NAME, -9 MATERIAL FROM 1018 & HEAD OD, WAS .24 , -5 MATERIAL FROM 0-1. ADDED BEARINGS & TOOLS COVERED CHART, AND BETTER MATERIAL DESCRIPTIONS. ALSO ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING. ALSO CHANGED TOL., OF-1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002-.000.		DATE	INITIAL	APPROVED
2					CHANGED -15 LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. CHANGED -11 & -13 FROM Ø.247 Ø.246 TO REAM Ø.290. ILLUMINATED -15 TYPE II PIN. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.		1/24/2008	WP	DW
3					ADDED .044 DEPTH TO KST1016-3 DIM. "C" AND LENGTHENED KST1016-7 TO ACCOMODATE BEARING AMB12V4012. ALSO REMOVED INER 25° ANDLE & ØB DIM.. FROM -13 SECONDARY SEAT.		2/19/2008	WP	G.E.
4					CHANGED -5 ROLLER RADIUS FROM .005 -.010 TO .015 -.020; AND -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. ALSO CHANGED -7 SLEEVE TO -7 GUIDE.		4/3/2008	WP	DW
5					CORRECTED KST1000-7 &1003-7 HT. FROM .25 TO .188 PER CUSTOMER COMPLAINT.		7/7/2008	WP	DW
5A					CH'D T/N FROM KST1000 THRU 1020.		11/19/2009	RJC	
6					-15 RBST1007-RBST1010 CH'D STOCK SIZE WAS Ø1/2 X 3/4 IS Ø5/8 X 3/4. -15 RBST1004-RBST1006 CH'D STOCK SIZE WAS Ø3/8 X 3/4 IS Ø1/2 X 3/4.		6/17/2013	BIM	GE
6A					-1 CORRECTED DIMENSION LEADER LINE THAT WAS NOT CORRECTLY POSITIONED, DID NOT CHANGE ANY DIMENSIONS.		8/6/2013	RJC	GE
7	15-0033				UPDATED TO NEW DRAFTING STANDARDS. ADDED "DRILL PRESS" TO TITLE. -1 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, UPDATED DIM TABLE. -1, -3, -11, -13, -15 IMPROVED GD&T. -9 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, -11 CH'D MATL FROM 4140 Q&T TO 4140/4142, ADDED HEAT TREAT RC 28-34. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, CH'D DIM WAS REAM Ø.249 P.F. -15 IS LIMITS Ø.2500-.2506. IMPROVED GD&T. -13 CH'D MATL FROM 4140 Q&T TO 4140/4142, ADDED HEAT TREAT RC 28-34. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, CH'D DIM WAS REAM Ø.249 P.F. -15 IS LIMITS Ø.2500-.2506. IMPROVED GD&T. -15 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, CH'D DIM WAS Ø.250 P.F. -11 & -13 IS LIMITS Ø.2510-.2514. REMOVED PIN TYPE FROM DIM TABLE. IMPROVED GD&T.		2/11/2015	DPD	SM



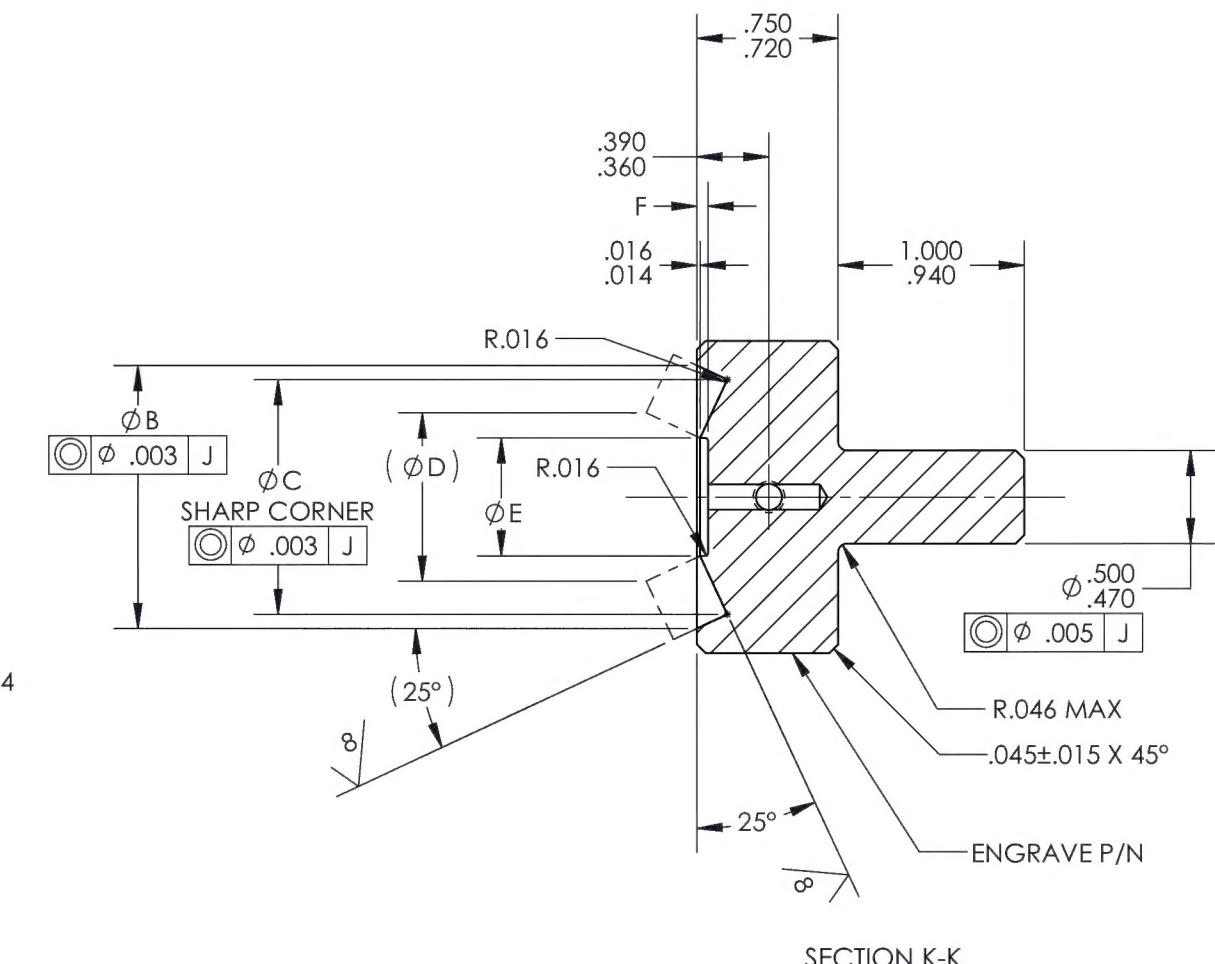
DART AEROSPACE		REV
TITLE RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL		7
DWG NO.	SEE TABLE	
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT	.XXX ± .005	FRACTIONS ± 1/8
FINISH	.XX ± .01	ANGLES ± 5°
SPEC	X ± .1	SURFACES = 125
DRAWN BY:	1. BREAK ALL SHARP EDGES	
CHECKED:	.015 x 45° OR .015R	
OPPS APPR:	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
QA APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
APPROVED:	LINDSAY	USED ON MODEL
SCALE	1:1	DATE 1/4/2008 SHEET 1 OF 9

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6A		-1 CORRECTED DIMENSION LEADER LINE THAT WAS NOT CORRECTLY POSITIONED, DID NOT CHANGE ANY DIMENSIONS.	8/6/2013	RJC	GE
7	15-033	-1 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. UPDATED DIM TABLE. IMPROVED GD&T.	2/13/2015	DPD	SM



TOOL NUMBER	ØA +.000 -.020	ØB +.008 -.000	ØC +.008 -.000	(ØD) (PD)	ØE +.008 -.000	F +.020 -.000	ØG +.000 -.001	H	K
RBST1000	1.250	.993	.846	.500	.238				
RBST1001									
RBST1002		1.056	.909	.563	.301				
RBST1003									
RBST1004									
RBST1005									
RBST1006									
RBST1007									
RBST1008									
RBST1009									
RBST1010									
RBST1011									
RBST1012									
RBST1013									
RBST1014									
RBST1015									
RBST1016									
RBST1017									
RBST1018									
RBST1019									
RBST1020	2.875	2.494	2.347	2.001	1.739	.058			



(-1)  
ROLLER  
FIXTURE

- NOTES:
1. BREAK ALL SHARP CORNERS .015-.030
  2. DIMENSION TO BOTTOM OF R.016=.153;  
DIMENSION TO SHARP CORNER=.158.
  3. DO FIRST ARTICLE INSPECTION BEFORE  
HEAT TREATING.

DART AEROSPACE	
TITLE RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL	
DWG NO.	SEE TABLE-1
	REV 7
MATERIAL	0-1 DRILL ROD
HEAT TREAT	RC 55-60
FINISH	ZINC PLATE
SPEC	QMSI-6.2.2, B.O. REV D
DRAWN BY:	PERRITT
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	MACKOVJAK
SCALE	1:1
DATE	1/4/2008
SHEET	2 OF 9

DART  
AEROSPACE

TITLE RBST1000 THRU 1020 DRILL PRESS  
TRI-ROLLER SWAGING TOOL

SEE TABLE-1

REV 7

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES

XXX ± .005 FRACTIONS ± 1/8

XX ± .01 ANGLES ± 5°

X ± .1 SURFACES = 125

1. BREAK ALL SHARP EDGES ✓

.015 x 45° OR. 015R

2. DIMENSIONAL LIMITS APPLY

AFTER PLATING

3. INTERPRET DIM AND TOL PER

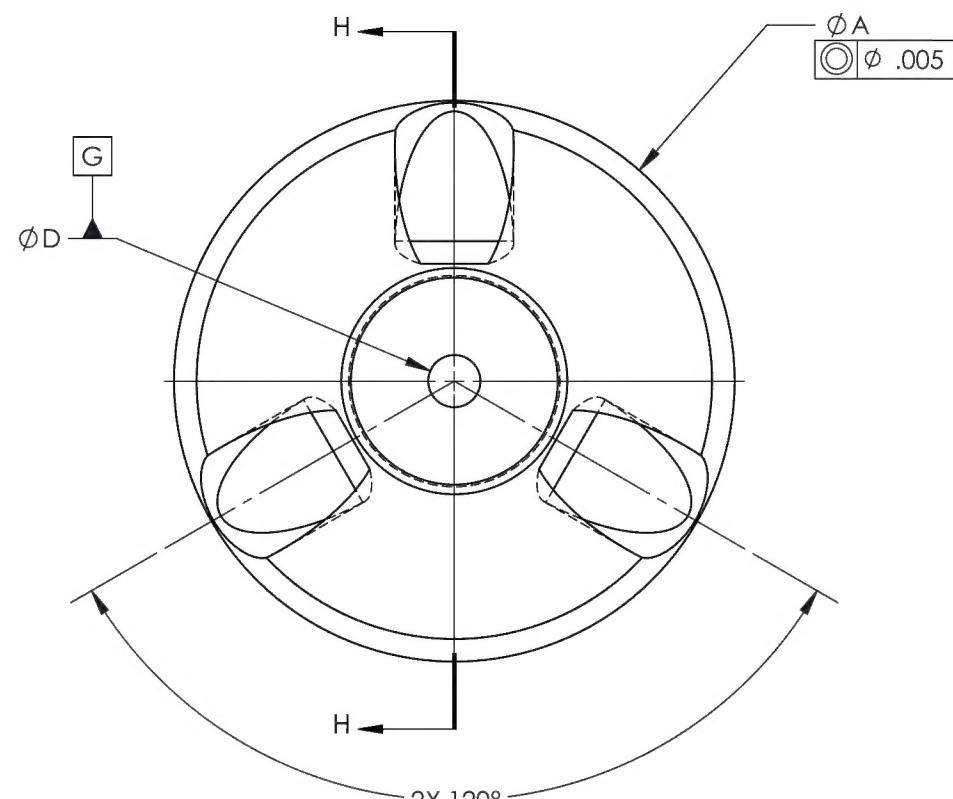
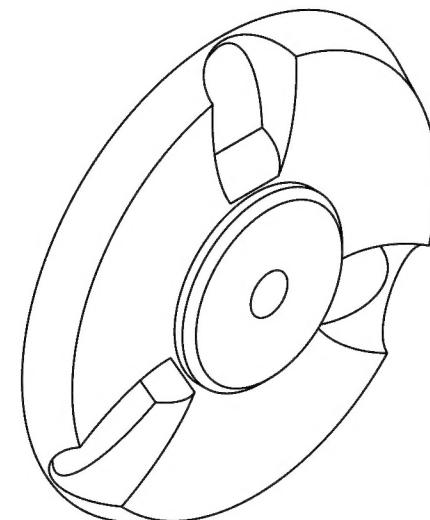
ASME Y14.5M-2009

USED ON MODEL

SEE TABLE

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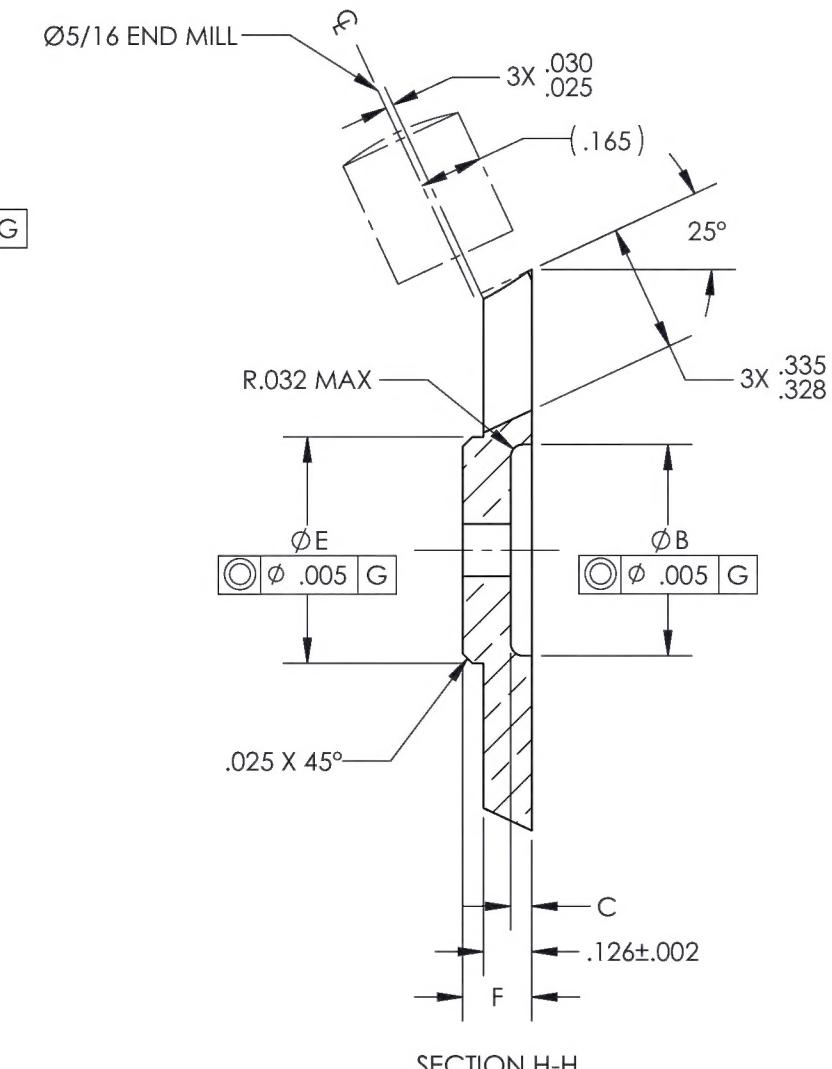
REV		ECR		DESCRIPTION		DATE		INITIAL		APPROVED	
7	15-0033	-3	IMPROVED GD&T.							2/13/2015	DPD SM



TOOL NUMBER	ØA +.002 -.002	ØB +.010 -.000	ØC +.020 -.000	ØD +.004 -.001	ØE +.000 -.015	F +.010 -.010	(P.D.)
RBST1000	1.075						.500
RBST1001							.563
RBST1002	1.140						.594
RBST1003	1.171						.625
RBST1004	1.212						.660
RBST1005	1.245						.712
RBST1006	1.297						.806
RBST1007	1.391	N/A	N/A				.837
RBST1008	1.422						.876
RBST1009	1.460						.900
RBST1010	1.485						.970
RBST1011	1.553						1.025
RBST1012	1.610						1.063
RBST1013	1.647						1.087
RBST1014	1.672						1.251
RBST1015	1.835	1.003	.055				1.313
RBST1016	1.897	1.016	.055				1.438
RBST1017	2.022	1.088	.019				1.501
RBST1018	2.085	N/A	N/A				1.626
RBST1019	2.210	1.252	.034				
RBST1020	2.585	1.517	.118				

(-3)

RETAINER



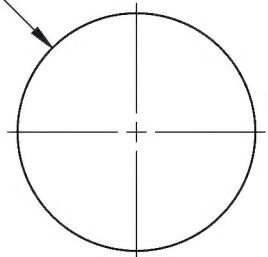
SEE TABLE-3		REV
MATL BRONZE	UNLESS OTHERWISE SPECIFIED	
HEAT TREAT	DIMENSIONS ARE IN INCHES	
FINISH	XXX ± .005 FRACTIONS ± 1/8	
X ± .01 ANGLES ± 5°		
X ± .1 SURFACES = 125		
SPEC		
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES	
CHECKED: MACKOVJAK	.015 X 45° OR. 015R	
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY	
QA APPR: LINDSAY	AFTER PLATING	
APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER	
	ASME Y14.5M-2009	
SCALE 2:1	USED ON MODEL	
	SEE TABLE	
DATE 1/4/2008		
SHEET 3 OF 9		

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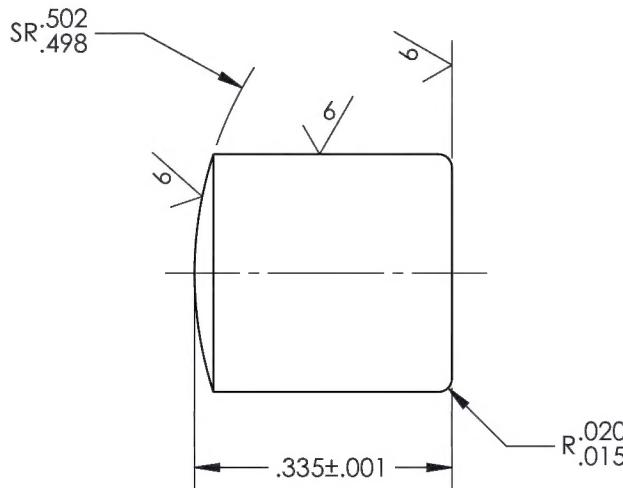
REV		ECR		REVISIONS		
				DESCRIPTION		DATE
				INITIAL	APPROVED	

TOOL NUMBER
RBST1000
RBST1001
RBST1002
RBST1003
RBST1004
RBST1005
RBST1006
RBST1007
RBST1008
RBST1009
RBST1010
RBST1011
RBST1012
RBST1013
RBST1014
RBST1015
RBST1016
RBST1017
RBST1018
RBST1019
RBST1020

$\phi .310$   
.309



ROLLER



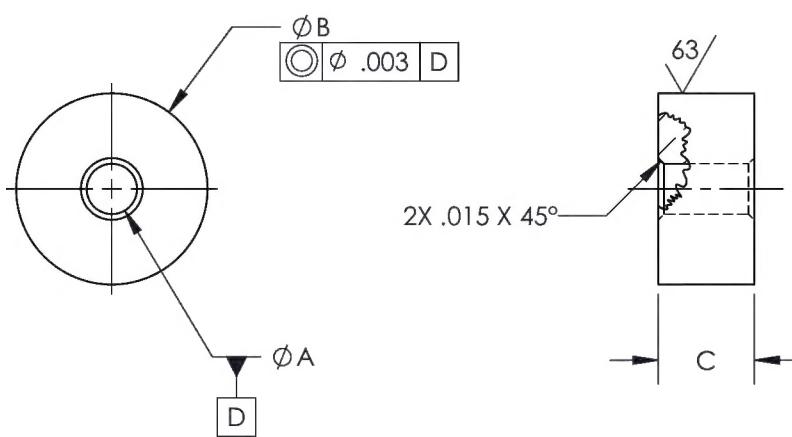
(5)

<b>DART</b> AEROSPACE		REV <b>7</b>
<b>TITLE</b> RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL		
<b>DWG NO.</b>		
<b>SEE TABLE-5</b>		
<b>MAT'L</b> STEEL      UNLESS OTHERWISE SPECIFIED HEAT RC 55-60      DIMENSIONS ARE IN INCHES TREAT      XXX ± .005      FRACTIONS ± 1/8 FINISH      XX ± .01      ANGLES ± 5° SPEC      X ± .1      SURFACES = 125 ✓ DRAWN BY: PERRITT CHECKED: MACKOVJAK OPPS APPR: ANDERSON QA APPR: LINDSAY      USED ON MODEL APPROVED: MACKOVJAK      SEE TABLE SCALE 4:1      DATE 1/4/2008      SHEET 4 OF 9		

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REV	ECR		DESCRIPTION	DATE	INITIAL	APPROVED
-----	-----	--	-------------	------	---------	----------

TOOL NUMBER	$\phi A$ +.001 -.001	$\phi B$ +.000 -.002	C +.000 -.010
RBST1000	.101	.188	.188
RBST1001			.250
RBST1002		.248	
RBST1003		.188	
RBST1004		.310	
RBST1005		.373	
RBST1006		.435	
RBST1007		.498	
RBST1008		.560	
RBST1009		.623	
RBST1010			
RBST1011			
RBST1012			
RBST1013			
RBST1014			
RBST1015			
RBST1016			
RBST1017			
RBST1018			
RBST1019			
RBST1020			



(-7)

GUIDE

NOTE:  
BREAK ALL SHARP CORNERS .015 - .030.

**DART**  
AEROSPACE

TITLE RBST1000 THRU 1020 DRILL PRESS  
TRI-ROLLER SWAGING TOOL

DWG NO.

SEE TABLE-7

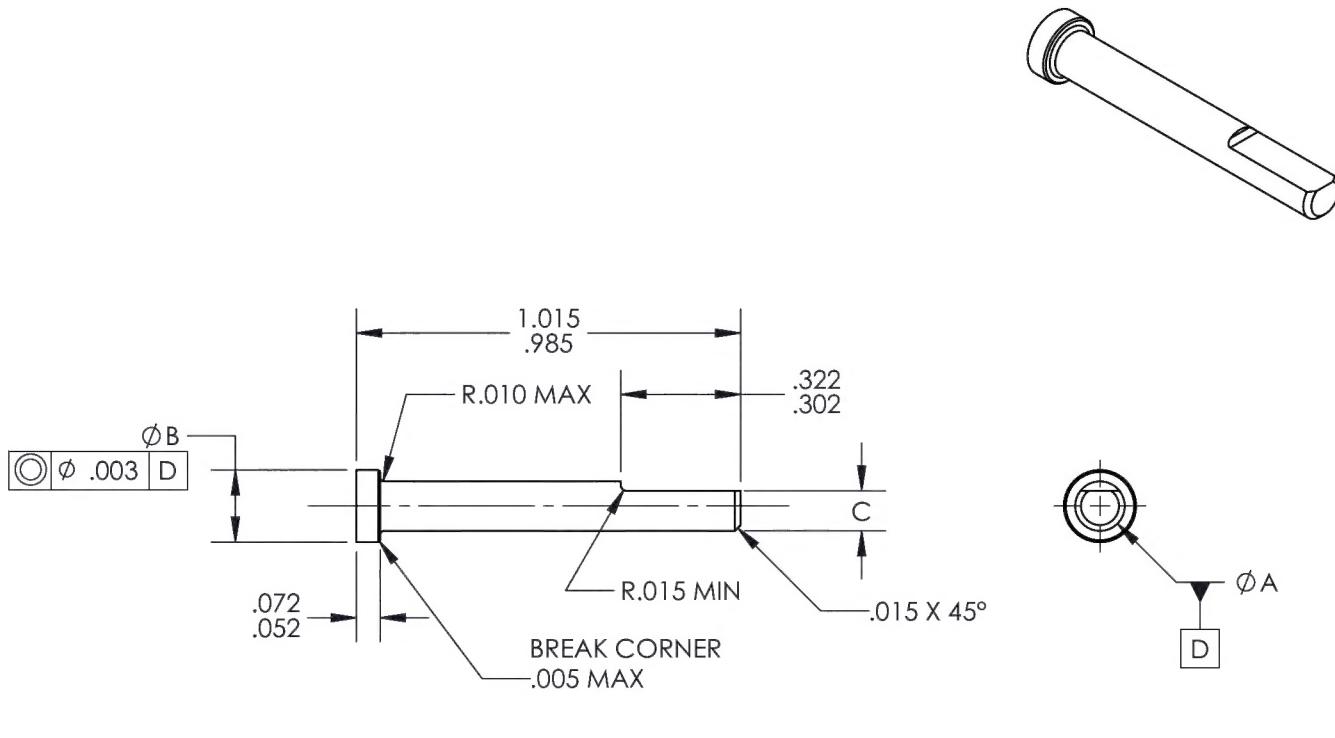
REV  
7

MAT'L	BRONZE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT		.XXX ± .005 FRACTIONS ± 1/8
TREAT		.XX ± .01 ANGLES ± 5°
FINISH		X ± .1 SURFACES = 125
SPEC		✓
DRAWN BY:	PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED:	MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	LINDSAY	USED ON MODEL
APPROVED:	MACKOVJAK	SEE TABLE
SCALE	2:1	DATE 1/4/2008
		SHEET 5 OF 9

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REVIEWS				DESCRIPTION			DATE	INITIAL	APPROVED
REV	ECR								
7	15-0033	-9	ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.				2/11/2015	DPD	SM

TOOL NUMBER	$\phi A$ +.000 -.001	$\phi B$ +.005 -.002	C +.000 -.020
RBST1000	.099	.156	.074
RBST1001			
RBST1002			
RBST1003			
RBST1004			
RBST1005			
RBST1006			
RBST1007			
RBST1008			
RBST1009			
RBST1010			
RBST1011			
RBST1012			
RBST1013			
RBST1014			
RBST1015			
RBST1016			
RBST1017			
RBST1018			
RBST1019			
RBST1020	.129	.188	.104



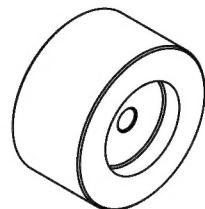
-9

PIN

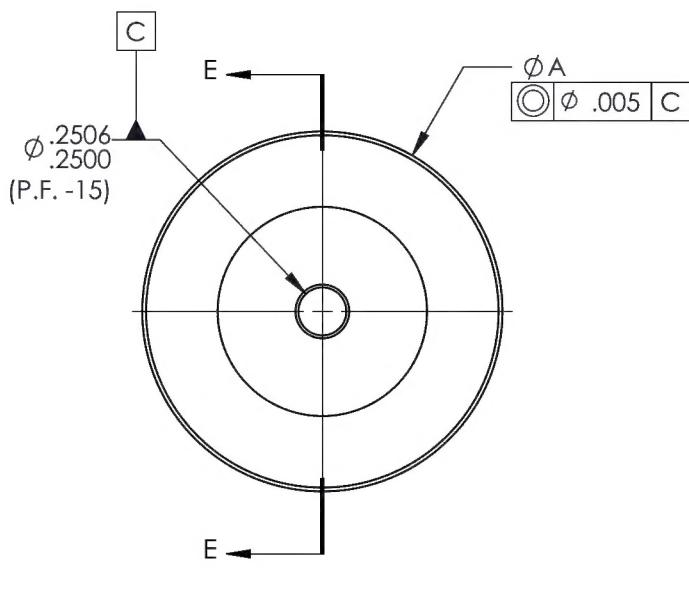
<b>DART</b> AEROSPACE		REV
TITLE		7
DWG NO.		SEE TABLE-9
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8	
FINISH	.XX ± .01 ANGLES ± 5°	
SPEC	X ± .1 SURFACES = 125 ✓	
QMSI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY:	PERRITT	2. DIMENSIONAL LIMITS APPLY
CHECKED:	MACKOVJAK	3. INTERPRET DIM AND TOL PER
OPPS APPR:	ANDERSON	ASME Y14.5M-2009
QA APPR:	LINDSAY	USED ON MODEL
APPROVED:	MACKOVJAK	SEE TABLE
SCALE	2:1	DATE 1/4/2008
		SHEET 6 OF 9

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REVIEWS			
REV	ECR	DESCRIPTION	DATE
7	15-0033	-11 CH'D MAT'L FROM 4140 Q&T TO 4140/4142. ADDED HEAT TREAD RC 28-34. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. CH'D DIM WAS REAM Ø.249 P.F. -15 IS LIMITS Ø.2500-.2506. IMPROVED GD&T.	2/17/2015 DPD SM

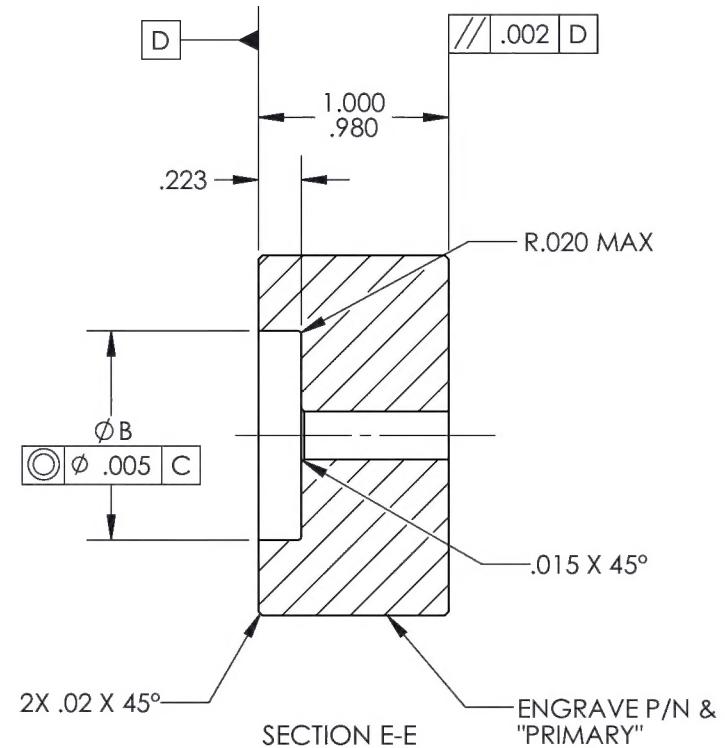


TOOL NUMBER	ØA +.000 -.030	ØB +.000 -.005
RBST1000	.2506	.2500
RBST1001		(P.F. -15)
RBST1002	.470	
RBST1003		
RBST1004	.505	
RBST1005		
RBST1006	.560	
RBST1007		
RBST1008	.630	
RBST1009		
RBST1010	.705	
RBST1011		
RBST1012	.755	
RBST1013		
RBST1014	.830	
RBST1015		
RBST1016	.885	
RBST1017		
RBST1018	.940	
RBST1019		
RBST1020	1.090	
RBST1021		
RBST1022	1.140	
RBST1023		
RBST1024	1.220	
RBST1025		
RBST1026	1.156	
RBST1027		
RBST1028	1.385	
RBST1029		
RBST1030	2.437	1.660



PRIMARY SEAT

(-11)



NOTE:  
BREAK ALL SHARP EDGES .015 - .030.



TITLE RBST1000 THRU 1020 DRILL PRESS  
TRI-ROLLER SWAGING TOOL

DWG NO.

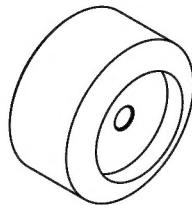
SEE TABLE-11

REV  
7

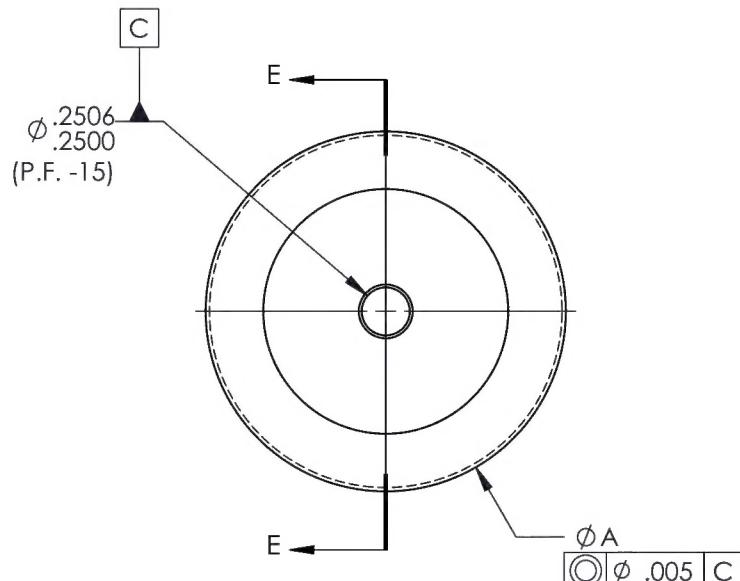
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 28-34	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	X ± .1 SURFACES = 125 ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	SEE TABLE
SCALE 1:1	DATE 1/4/2008
	SHEET 7 OF 9

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REVIEWS			
REV	ECR	DESCRIPTION	DATE
7	15-0033	-13 CH'D MAT'L FROM 4140 Q&T TO 4140/4142. ADDED HEAT TREAT RC 28-34. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. CH'D DIM WAS REAM Ø.249 P.F. -15 IS LIMITS Ø.2500-.2506. IMPROVED GD&T.	2/17/2015 DPD SM

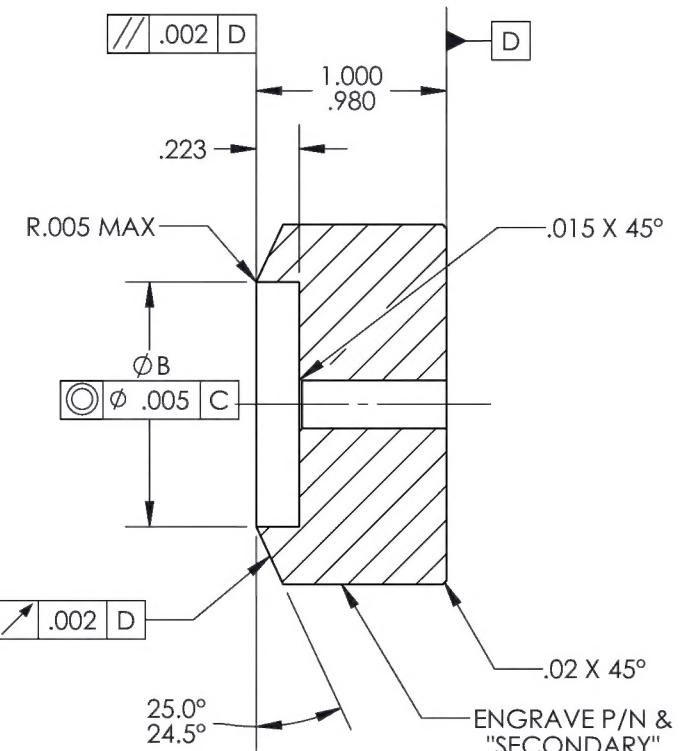


TOOL NUMBER	ØA +.000 -.030	ØB +.000 -.005
RBST1000	.500	
RBST1001	.563	
RBST1002	.586	
RBST1003	.625	
RBST1004	.660	
RBST1005	.712	
RBST1006	.806	
RBST1007	.837	
RBST1008	.875	
RBST1009	.900	
RBST1010	.968	
RBST1011	1.025	
RBST1012	1.062	
RBST1013	1.087	
RBST1014	1.250	
RBST1015	1.312	
RBST1016	1.437	
RBST1017	1.500	
RBST1018	2.062	
RBST1019	1.625	
RBST1020	2.437	2.000



(-13)

SECONDARY  
SEAT



### SECTION E-E

NOTE:  
BREAK ALL SHARP CORNERS .015 - .030.

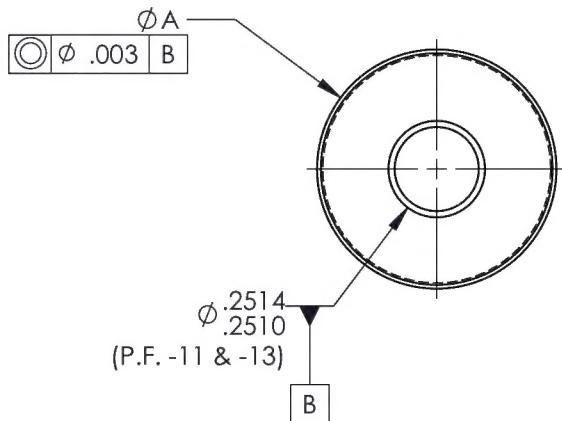


TITLE RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL		REV 7
DWG NO. SEE TABLE-13		
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED	DIMENSIONS ARE IN INCHES
HEAT TREAT RC 28-34	.XXX ± .005	FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01	ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	X ± .1	SURFACES = 125 ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY	USED ON MODEL	
APPROVED: MACKOVJAK	SEE TABLE	
SCALE 1:1	DATE 1/4/2008	SHEET 8 OF 9

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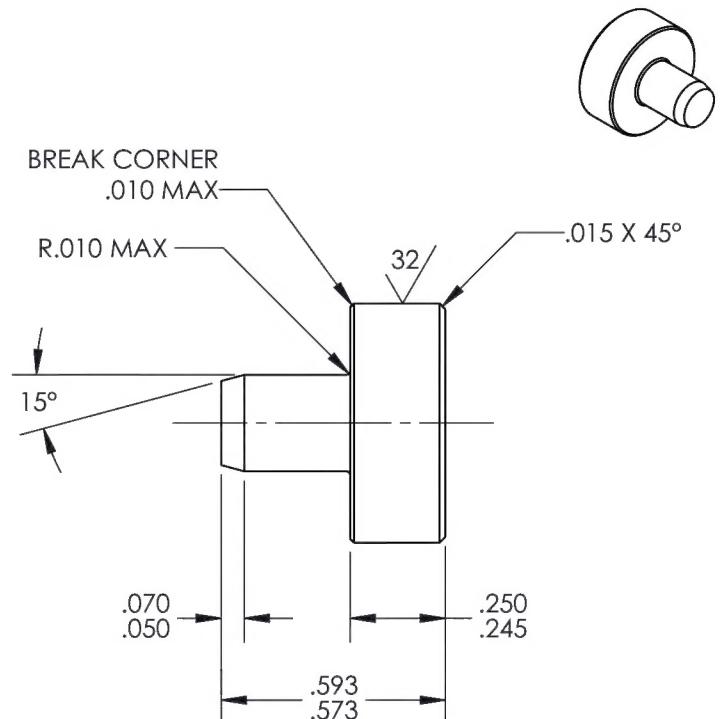
REVISIONS			
REV	ECR	DESCRIPTION	DATE
6		-15 RBST1007-RBST1010 CH'D STOCK SIZE WAS $\varnothing 1/2 \times 3/4$ IS $\varnothing 5/8 \times 3/4$ . -15 RBST1004-RBST1006 CH'D STOCK SIZE WAS $\varnothing 3/8 \times 3/4$ IS $\varnothing 1/2 \times 3/4$ .	6/17/2013
7	15-0033	-15 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. CH'D DIM WAS $\varnothing .250$ P.F. -11 & -13 IS LIMITS $\varnothing .2510-.2514$ . REMOVED PIN TYPE FROM DIM TABLE. IMPROVED GD&T.	2/17/2015

TOOL NUMBER	$\varnothing A$ +.000 -.002
RBST1000	.188
RBST1001	
RBST1002	.248
RBST1003	
RBST1004	.310
RBST1005	
RBST1006	.373
RBST1007	
RBST1008	.435
RBST1009	
RBST1010	.498
RBST1011	
RBST1012	.560
RBST1013	
RBST1014	.623
RBST1015	
RBST1016	.748
RBST1017	
RBST1018	.873
RBST1019	
RBST1020	.998



LOCATING PIN

(-15)



<b>DART</b> <b>AEROSPACE</b>	
TITLE RBST1000 THRU 1020 DRILL PRESS TRI-ROLLER SWAGING TOOL	
DWG NO.	SEE TABLE-15
REV 7	
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH	X ± .1 SURFACES = 125
SPEC	QMSI-6.2.2, B.O. REV D
DRAWN BY:	PERRITT
CHECKED:	MACKOVJAK
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	MACKOVJAK
SCALE	2:1
DATE	1/4/2008
USED ON MODEL	
SEE TABLE	
ASME Y14.5M-2009	